

Date: Friday, 11/17/2006 9:07:52 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
<b>Job Number</b> : 29510	
<b>Estimate Number</b> : 10530	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2571
<b>This Issue</b> : 11/17/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2571 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 29159	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 12/5/2006
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	<b>Qty:</b> 16 <b>Um:</b> Each
<b>Comment</b> : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2571  
 Ensure that grain is along 7.75" length  
 Batch No: *B25353*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. *29510* Double check by: *SD*

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets ✓
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ✓
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2571 & D2572

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 11/17/2006 9:07:53 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 29510

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3.1 06/12/10 16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06/12/18

16x

7.0

POWDER COATING

POWDER COATING



M 10 2 3 9 1



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-B/a.m 06/12/10 16

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/12/19 16

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5771

06/14/19 16

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/19

Job Completion



C 06/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>24510</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	<del>DT8682</del>	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	7.999	7.998	7.998		
F	0.490	0.510		0.496	0.503	0.502	0.502		
G	0.257	0.262	<del>DT8683</del>	0.258	0.258	0.258	0.258		
H	0.375	0.380	<del>DT8684</del>	0.377	0.376	0.376	0.376		
I	0.490	0.510		0.497	0.498	0.500	0.500		
J	1.174	1.184		1.179	1.178	1.178	1.179		
K	0.558	0.578		0.568	0.564	0.567	0.569		
L	1.174	1.184		1.179	1.178	1.178	1.179		
M	1.490	1.500		1.495	1.494	1.496	1.495		
N	2.495	2.505		2.500	2.506	2.500	2.500		
O	3.869	3.879		3.874	3.872	3.872	3.872		
P	0.115	0.135		0.125	0.126	0.126	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.251	0.251	0.251		
S	0.115	0.135		0.128	0.130	0.129	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.959	2.966	2.961	2.961		
V	0.230	0.250		0.242	0.242	0.242	0.246		
W	0.115	0.135		0.123	0.129	0.129	0.130		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.360	0.365	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.632	0.632	0.632		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.252	0.252	0.254	0.247		
AE	1.375	1.395		1.386	1.385	1.385	1.386		
AF	0.115	0.135		0.133	0.122	0.130	0.130		
AG	0.240	0.280		0.245	0.260	0.263	0.263		
AH	0.240	0.260		0.250	0.251	0.251	0.250		
AI	2.000	2.020		2.000	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	JL
Date:	06.11.24 / 06/11/27

Audited by:	JL
Date:	06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>29510</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

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				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	<del>DT8682</del>	0.440	0.439	0.439	0.440		
B	1.745	1.755		1.756	1.750	1.748	1.750		
C	3.495	3.505		3.506	3.500	3.500	3.506		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.999	7.998		
F	0.490	0.510		0.503	0.503	0.503	0.500		
G	0.257	0.262	<del>DT8683</del>	0.258	0.258	0.258	0.258		
H	0.375	0.380	<del>DT8683</del>	0.376	0.376	0.376	0.377		
I	0.490	0.510		0.499	0.499	0.500	0.498		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.567	0.566	0.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.497	1.495	1.494	1.494		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	3.869	3.879		3.874	3.872	3.872	3.873		
P	0.115	0.135		0.127	0.127	0.128	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.130	0.130	0.131	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.240	0.241	0.240		
W	0.115	0.135		0.126	0.127	0.127	0.127		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.364	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.633	0.633	0.633	0.635		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.248	0.250		
AE	1.375	1.395		1.386	1.386	1.387	1.387		
AF	0.115	0.135		0.125	0.125	0.128	0.132		
AG	0.240	0.280		0.256	0.258	0.254	0.260		
AH	0.240	0.260		0.250	0.250	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.003	2.001		
AJ	0.023	0.043		0.036	0.030	0.030	0.036		
Accept/Reject									

Measured by:	<i>mf</i>
Date:	06/11/27

Audited by:	J.L
Date:	06/10/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>29510</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
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Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	.439	.439	.439	0.446		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.995	8.000	8.000	8.002		
F	0.490	0.510		.498	.495	.496	0.501		
G	0.257	0.262	DT8683	.258	.258	.258	0.258		
H	0.375	0.380	DT8684	.376	.376	.376	0.377		
I	0.490	0.510		.499	.499	.499	0.499		
J	1.174	1.184		1.179	1.175	1.179	1.175		
K	0.558	0.578		.566	.567	.568	0.564		
L	1.174	1.184		1.179	1.175	1.179	1.175		
M	1.490	1.500		1.493	1.493	1.493	1.492		
N	2.495	2.505		2.500	2.508	2.500	2.495		
O	3.869	3.879		3.874	3.874	3.874	3.872		
P	0.115	0.135		.126	.127	.127	0.172		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.250	.257	.251	0.251		
S	0.115	0.135		.130	.129	.129	0.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.962		
V	0.230	0.250		.240	.240	.238	0.238		
W	0.115	0.135		.125	.122	.123	0.124		
X	0.308	0.313		.311	.311	.311	0.310		
Y	0.760	0.765		.761	.761	.761	0.765		
Z	0.352	0.372		.363	.363	.363	0.361		
AA	0.470	0.530		.500	.500	.500	0.500		
AB	0.615	0.635		.624	.624	.623	0.629		
AC	0.053	0.073		.063	.063	.063	0.063		
AD	0.240	0.260		.250	.248	.248	0.247		
AE	1.375	1.395		1.386	1.387	1.389	1.387		
AF	0.115	0.135		.134	.134	.134	0.135		
AG	0.240	0.280		.250	.250	.257	0.260		
AH	0.240	0.260		.249	.248	.248	0.248		
AI	2.000	2.020		2.001	2.002	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	0.030		
Accept/Reject									

Measured by: SD / En  
Date: 06.11.28 / 06.11.29

Audited by: J.L  
Date: 06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	29510
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.750	1.751	1.746		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.751	1.746		
E	7.990	8.010		8.002	8.003	8.003	8.003		
F	0.490	0.510		0.500	0.500	0.500	0.499		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.499	0.498	0.502		
J	1.174	1.184		1.175	1.176	1.176	1.176		
K	0.558	0.578		0.566	0.565	0.562	0.566		
L	1.174	1.184		1.175	1.176	1.176	1.176		
M	1.490	1.500		1.493	1.493	1.494	1.495		
N	2.495	2.505		2.498	2.500	2.499	2.497		
O	3.869	3.879		3.872	3.872	3.873	3.870		
P	0.115	0.135		0.127	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.251	0.251	0.251		
S	0.115	0.135		0.129	0.128	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.964	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.237	0.240	0.239		
W	0.115	0.135		0.122	0.123	0.123	0.123		
X	0.308	0.313		0.310	0.310	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.365	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.627	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.250	0.246	0.246		
AE	1.375	1.395		1.388	1.387	1.386	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.247	0.248	0.248		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	SD / E
Date:	06.11.28 / 06/11/29

Audited by:	J.L
Date:	06/12/10

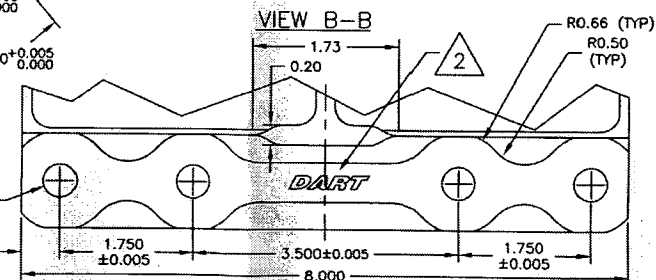
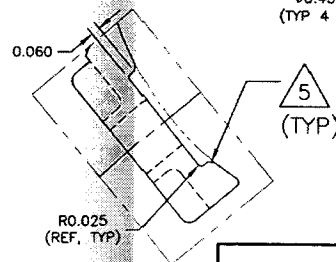
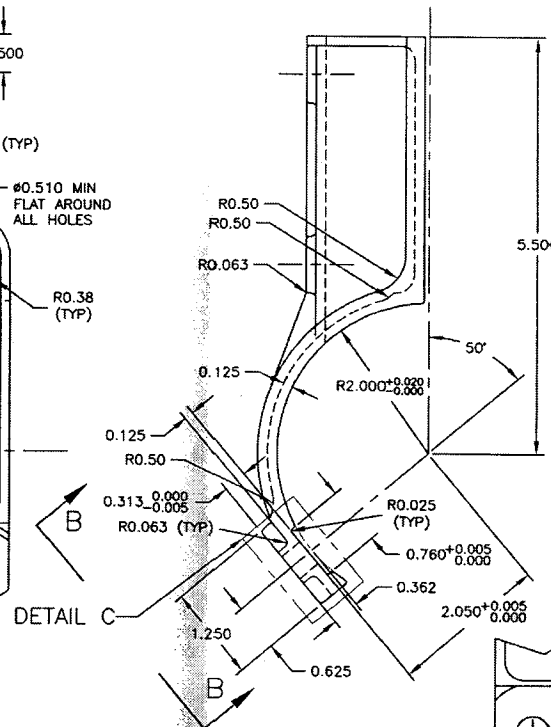
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	







05.12.06

MATERIAL: 7075-17351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- $\triangle E$



DETAIL C  
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		
CHECKED	APPROVED	DRAWING NO.
		D2571
DATE		TITLE
05.07.13		OUTER FWD SADDLE
		REV. SHEET 1 OF 1
		SCALE
		2:

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NO. 29510